

Having thus described the preferred embodiment, the invention is now claimed to be:

1. An ink cartridge comprising:
 - a housing having a plurality of walls forming a top surface, a bottom surface, and side surfaces connecting said top and bottom surfaces, said walls forming a chamber adapted to receive ink;
 - an outlet passage extending from said bottom surface communicating with said chamber and through which ink is selectively dispensed;
 - a seal attached to said outlet passage; and
 - a first cap which secures said seal to said passage.
2. The ink cartridge of claim 1 further comprising a vent formed on said top surface.
3. The ink cartridge of claim 2 wherein said vent comprises an opening, a porous member, and a second cap, wherein said porous member is secured within said opening via said cap.
4. The ink cartridge of claim 3 wherein said porous member has cell sizes adapted to allow air in flow to substantially equal ink out flow from the cartridge.
5. The ink cartridge of claim 3 wherein said second cap is a screw cap which is threadedly secured to said vent.
6. The ink cartridge of claim 1 wherein said first cap is a screw cap which is threadedly secured to said outlet passage.
7. The ink cartridge of claim 1, wherein said housing is a one-piece integral construction.
8. The ink cartridge of claim 1, wherein said housing is formed of blow-molded plastic material.

9. The ink cartridge of claim 1, wherein said housing is adapted to be fully filled with ink.

10. The ink cartridge of claim 1, wherein said housing receives pigmented ink.

11. The ink cartridge of claim 2, wherein said vent comprises a ball and a spring mechanism secured to said ball.

12. The ink cartridge of claim 2, wherein said vent comprises a diaphragm valve.

13. The ink cartridge of claim 12, wherein said diaphragm valve is substantially T-shaped.

14. The ink cartridge of claim 2, wherein said vent comprises a suction tube which extends from said vent to said bottom surface, and a cap to secure said tube to said vent.

15. An ink cartridge comprising:
a unitary, one-piece housing comprising a top wall, bottom wall, and a plurality of side walls which form a chamber for receiving ink;
an outlet passage extending from said bottom wall communicating with said chamber and through which ink is selectively dispensed; and
a vent formed in said top wall for allowing air to enter said chamber.

16. The ink cartridge of claim 15, wherein said housing is formed of blow-molded plastic material.

17. The ink cartridge of claim 15, wherein said vent comprises an opening, a porous member and a screw cap for securing said porous member within said opening.

18. The ink cartridge of claim 15, wherein said housing further comprises a flexible seal selectively attached to said

outlet passage and a screw cap which secures said seal to said passage.

19. The ink cartridge of claim 15, wherein said housing is adapted to be fully filled with pigmented ink.

20. A method of forming an ink cartridge comprising the steps of:

molding a housing having an integral top wall, bottom wall and interconnecting side walls, defining an internal chamber that communicates with a vent and outlet passage;

sealing the vent with a check valve assembly; and
installing a seal member to the outlet passage.

21. The method of claim 20 wherein the molding step includes using a fluid pressure assist to blow-mold the housing.